

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016154**Date Inspected:** 02-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA.**CWI Name:** R. Rodriguez, R. Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Westmont Industries (WMI) in Santa Fe Springs, CA, to randomly observe the in process welding of the Travelers. The QA Inspector arrived on site to randomly observe the WMI Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

**Traveler E2/E3-EB**

On this date, the QA Inspector observed Westmont Industries (WMI) production personnel Mr. Tim Hartnett, cutting material for the E2/E3-EB Traveler.

The QA Inspector observed that Mr. Hartnett was utilizing a Marvel Brand 15 A series horizontal band saw, to perform the cutting operations at production station # 1 and observed that the material being cut, was identified as 1 ½" x 1 ½" x .125" square tube steel.

Mr. Harnett explained to the QA Inspector that he was provided a list of material to be cut to a specific length, by the WMI shop supervisor, Mr. George Grayum, per the shop drawings. Mr. Harnett explained that he was cutting the material to these specific lengths and marking the material with a white paint stick marker, to identify the individual cut pieces of material, per the shop drawing bill of material list. The QA Inspector observed that Mr. Harnett identifying the square tube steel as piece marks B255 and AP.

The QA Inspector verified the dimensions of the square tube steel, per the shop drawings and the tube steel appeared to be in compliance.

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The QA Inspector observed that after the material was cut to length and identified, that the material was then transferred to another production station, identified as station # 2. Mr. Harnett explained further that at this station, the required angles will then be marked for cutting, on the end or ends of the square tubing.

The QA Inspector observed that the square tube steel, had been previously inspected by WMI QC Inspector Rick Rodriguez and that the Mill Test Report's (MTR's) had been previously provided to the QA Inspector.

The QA Inspector observed that the above mentioned material had been previously inspected by the QA Inspector and appeared to be in compliance with the contract requirements.

### Material, Equipment, and Labor Tracking (MELT)

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Westmont Industries: 1 QC, 1 supervisor and 1 production personnel.

### Summary of Conversations:

On this Date, the QA Inspector was informed by production personnel Tim Harnett that WMI will not be cutting material the entire shift, for the E2/E3-EB Traveler today. Mr. Harnett explained that he was instructed by shop supervisor George Grayum to utilize the Marvel Brand 15 A series horizontal band saw, for cutting operations on another project. The QA Inspector later observed that no cutting operations were being performed the remainder of the shift and observed that each of the 3 stations which are utilized for the cutting and layout of the Traveler material, were being utilized for another WMI project.

On this date, WMI QCM Rick Rodriguez explained that WMI production shop welders will be performing qualification tests, for the future tacking and welding activities, on the Travelers. Mr. Rodriguez explained that the welders will be performing a fillet weld test, per AWS D1.1 Figure 4.20.

The QA Inspector observed that Smith-Emery QC Inspector Ruben Dominguez was present, to witness the qualification tests.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Vance,Sean	Quality Assurance Inspector
<b>Reviewed By:</b>	Edmondson,Fred	QA Reviewer

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